

5745

SPLIT-2

DART AEROSPACE LTD		Work Order:	24084
Description: Long Step Assembly - High Skid, RH		Part Number:	D350-591-312
			704A 41 640 011
Dwg: D3272 Rev. A		Qty:	10
		Page 1 of 2	

7/10/11

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	DA	05.08.23	10
2	DC	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001	DA	05-10-31	10
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3272 using cutting table Setup DT 81852A. Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion 324092	HE	06-02-8	10
4	GA	Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.	HE	06-02-14	10
5	GA	Deburr	HE	06-02-14	10
6	QC5	Inspect work to Step 5	DA	06/02/14	10
7	WA	Bevel end for welding FWD ONLY	HE	06/02/14	10
8	WA	Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 324566 2 D3219-1 Support 324567 A/R Aluminum Rod M12238 M12239	HE	06/02/14	10
9	GA	Grind End Plate flush	FF	06/02/15	10
10	QC9 & 5	Inspect weld and work to Step 9	DA	06-02-17	10
11	FP	Chemical conversion coat as per QSI 005 4.1	FF	06.02.20	10
12	GA	Assemble Leg Assembly as per Dwg D3272. (D3066-1 is part of D3065-041 Step Leg Assembly, do not add to BOM.) Pick: Qty Part Number Description Batch 1 D3065-041 Step Leg Assy 324093 2 D3066-1 Spacer 325056 16 MS20600AD4W4 Rivet M19185	HE	06-02-25	10
13	QC5	Inspect work to step 12	HE	06-02-25	10
14	WA	Bevel Aft end for welding	HE	06-02-25	10
15	WA	Inspect for foreign object as per QSI 024	HE	06-02-25	10
16	WA	Weld Aft End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 324097 A/R Aluminum Rod M12238	HE	06-02-27	10
		Identify as D3272-042			

RELEASED
04.03.22

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17	GA	Grind End Plate flush		06-03-01	10																																																																
18	QC9 & 5	Inspect work to Step 17 – Check dimension 108.93" & 3.375" as per Dwg D3272		06-03-02	10																																																																
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	DL	06/03/06	10																																																																
20	FP	Wing Walk as per Dwg D3272 and QSI 005 4.4	DL	06/03/06	10																																																																
21	QC3	Inspect Powder Coat and Wing Walk	FL	06 03 06	10																																																																
22	KP	<p>Pick: Packing Kit (Note: D3272-042 is on BOM as material listed in Step 3)</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2230-3</td><td>Mounting Lug</td><td>4x B24397/30x B24090</td></tr><tr><td>2</td><td>D2618</td><td>Bushing</td><td>B24091</td></tr><tr><td>2</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B24237B</td></tr><tr><td>2</td><td>D3235-1</td><td>Mounting Lug</td><td>2x B24409/18x B24567</td></tr><tr><td>1</td><td>D3272-042</td><td>Step Assembly</td><td>B24084</td></tr><tr><td>1</td><td>D3278-041</td><td>Support Assembly</td><td>2x B24096/18x B24568</td></tr><tr><td>2</td><td>AN3-35A</td><td>Bolt</td><td>M17944</td></tr><tr><td>8</td><td>AN4-13A</td><td>Bolt</td><td>M18367</td></tr><tr><td>2</td><td>AN5-36A</td><td>Bolt</td><td>M16114</td></tr><tr><td>4</td><td>AN960JD10</td><td>Washer</td><td>M19521</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M19085</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M18100</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M18917</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M17997</td></tr><tr><td>2</td><td>MS21042L5</td><td>Nut (or -5)</td><td>4x M5289/16x M19073</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2230-3	Mounting Lug	4x B24397/30x B24090	2	D2618	Bushing	B24091	2	D2856-400-720	Abrasion Strip	B24237B	2	D3235-1	Mounting Lug	2x B24409/18x B24567	1	D3272-042	Step Assembly	B24084	1	D3278-041	Support Assembly	2x B24096/18x B24568	2	AN3-35A	Bolt	M17944	8	AN4-13A	Bolt	M18367	2	AN5-36A	Bolt	M16114	4	AN960JD10	Washer	M19521	16	AN960JD416	Washer	M19085	4	AN960JD516	Washer	M18100	2	MS21042L3	Nut (or -3)	M18917	8	MS21042L4	Nut (or -4)	M17997	2	MS21042L5	Nut (or -5)	4x M5289/16x M19073			
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23	QC4	Inspect Kit 100% for Completeness on the W/O		06/03/02	10																																																																
24	PK	Package for shipping as per PPP D350-591-312		06-03-09																																																																	
25	AC	Cost / part	Rev B	06/03/09	(3)																																																																
26	DC	Close W/O Inspect Level 21		06/03/09	10																																																																

Rev	Date	Change	Revised By	Approved
A	04.03.22	New issue	KJ/RF	

RELEASED
04.03.22

Job Costing Report

Aug 18, 2005
10:59 am

Dart Aerospace Ltd.
Hawkesbury

Work Order No : 0024084
Project Name : D350-591-312
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : *D350-591-312
Description : Heli-Access-Step, RH Hi
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 08-16-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00